

**Work Order ID 65935**

Thursday, January 27, 2011 1:08:42 PM

Page 1

Item ID: D4018-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Short Basket Lid Assembly (350)

Start Date: 1/28/2011 Start Qty: 1.00

Required Date: 2/14/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: mf Date: 11-01-27 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D4018	C
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100

Weld per dwg A/R S.S. rod Batch: 1114699 0.00

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D4018 using DT9607B  
2- weld hinge (3) and Mounting brackets as per dwg D4018  
\*\*\*inspect before welding mesh\*\*\*  
3- tack weld mesh on basket as per dwg D4018  
\*\*\*make sure to place mesh correctly on lid, check with label plate before  
tacking mesh\*\*\*

11/02/09 (1X)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-02-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

\*\*\* mask sides of hinge prior to powdercoat\*\*\*

Start Time: 9:30

Oven Temperature: 320°

Finish Time: 1:00

140

Wing Walk as per dwg QSI005 4.4 Batch 11164020

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- install label

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*ES 11/02/14 @*

160

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

0.00

Packaging

*w/o 65942**ES 11/02/14 @*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*OK 11/02/16**MF 11-02-15*

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# Picklist Print

Thursday, January 27, 2011 1:08:39 PM

Page 1

Work Order ID: 65935

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350 )





Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4018-1  Rib		Manufactured	No			100	Each	2.0000	2	2		11/02/09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					59252			2					
D4018-3  Rib		Manufactured	No			100	Each	2.0000	2	2		11/02/09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					59253			2					
D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	14.0000	3	3		11/02/09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				14					
					64845			8					
					65425			6					
D4018-5  Rib		Manufactured	No			100	Each	16.0000	6	6		11/02/09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				16					
					64067			16					

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 65935

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350 )

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-041 Manufactured No

100

Each

1.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)



B65426 (1x) MY 11/02/09

Location

Loc Qty

Loc Code

WA

1

64849

1

D4035-043 Manufactured No

100

Each

1.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



B65427 (1x) MY 11/02/09

Location

Loc Qty

Loc Code

WA

1

64850

1

D2581 Manufactured No

100

Each

29.0000

2

2



Mounting Bracket



MY 11/02/09

Location

Loc Qty

Loc Code

WA

29

64112

20

64425

9

D4020-7 Manufactured No

100

Each

0.0000

1

1



Mesh (350 Basket Short, Lid)



MY 11/02/09 B65917 (1x)

D4021-3 Manufactured No

100

Each

3.0000

1

1



Data Plate



B65916 (1x) MY 11/02/09

Location

Loc Qty

Loc Code

WA

3

56050

1

64924

2

Thursday, January 27, 2011 1:08:40 PM

Shop Packet Print

Page 2

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, January 27, 2011 1:08:40 PM

Page 3

Work Order ID: 65935



Parent Item: D4018-041



Parent Item Name: Short Basket Lid Assembly (350 )

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label

M115050



(x1) 21 110212

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

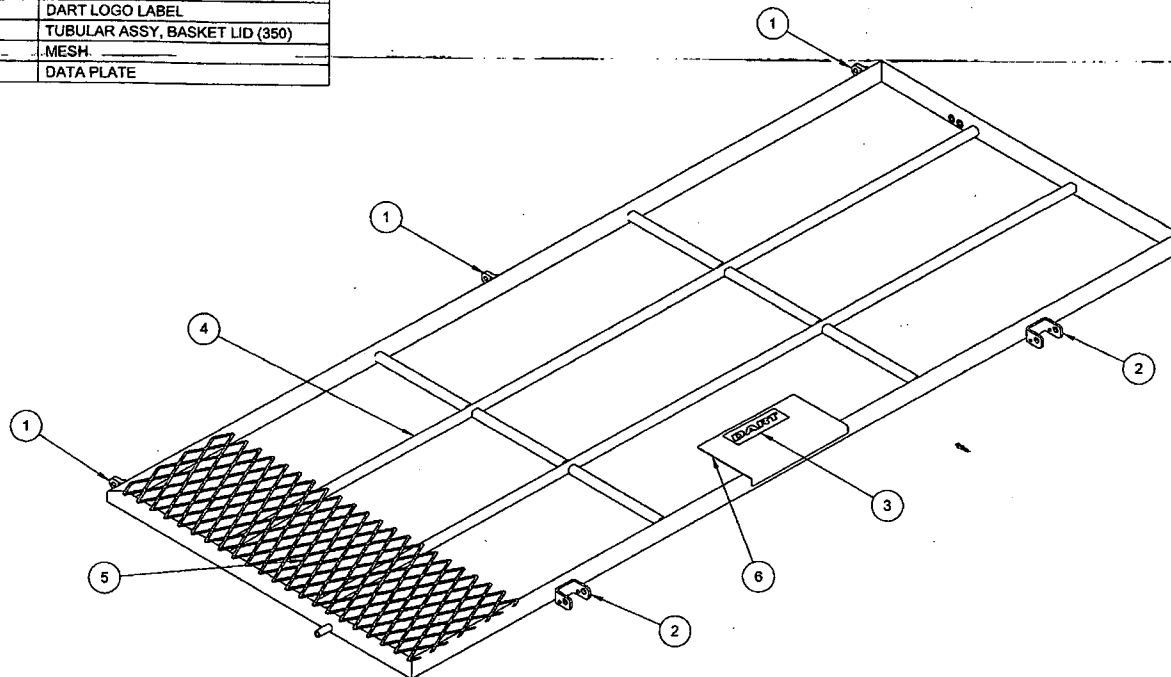
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



**D4018-041 SHORT BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
10.08.12  
ECN 10-596

C	REMOVED D4088-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4088-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. C
CHECKED	SC	D4018	SHEET 1 OF 4
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AS	SHORT BASKET LID ASSY (350)	NTS
DE APPR.	AS	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

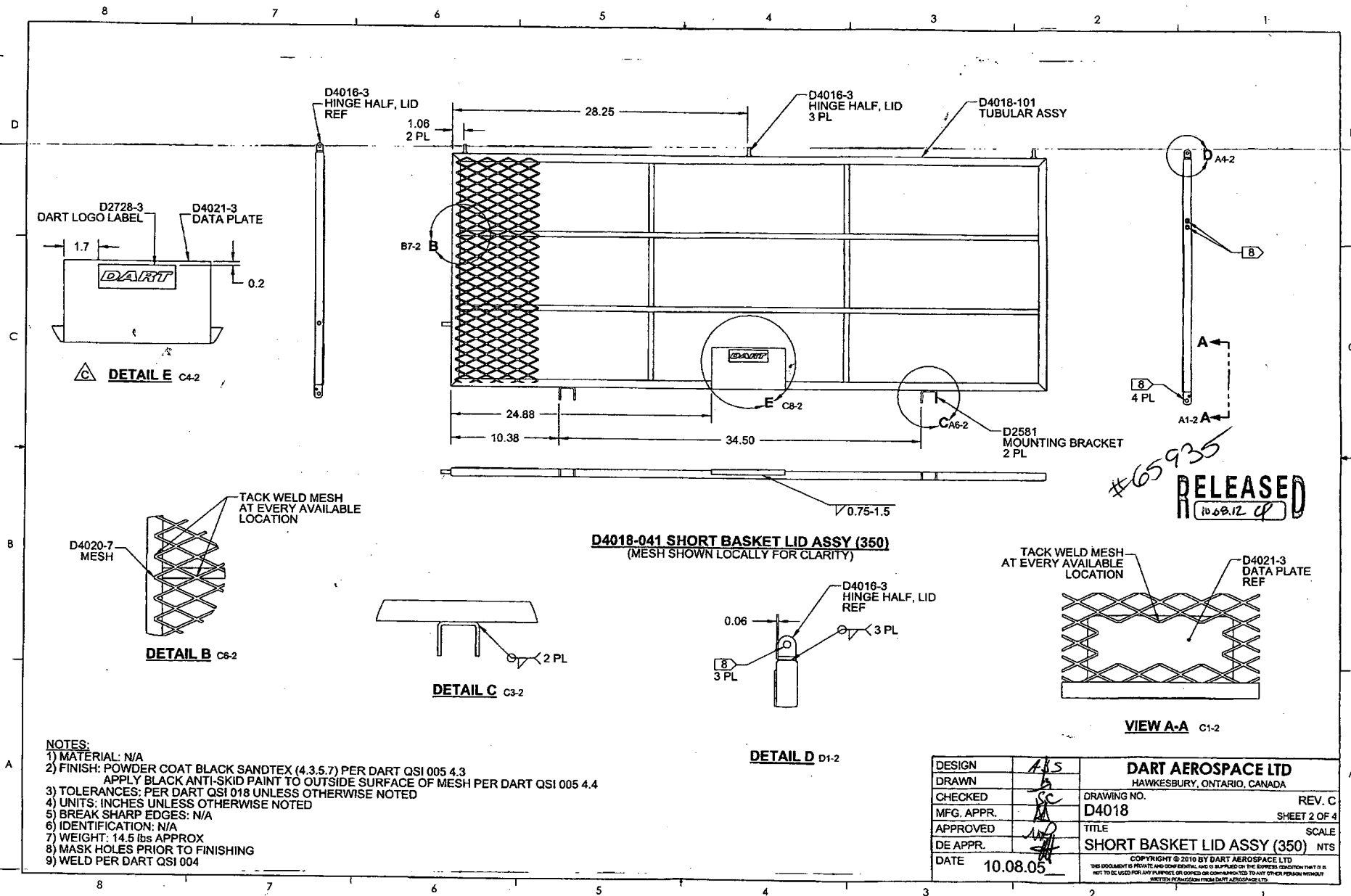
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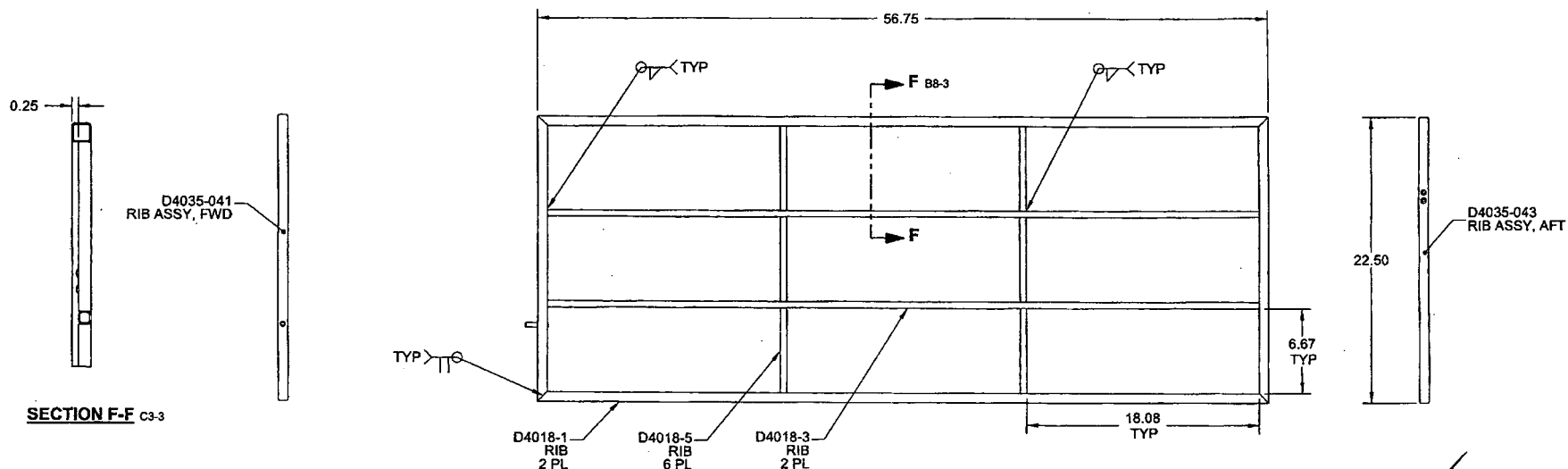
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	LS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 3 OF 4
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	SHORT BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED  
10.08.12

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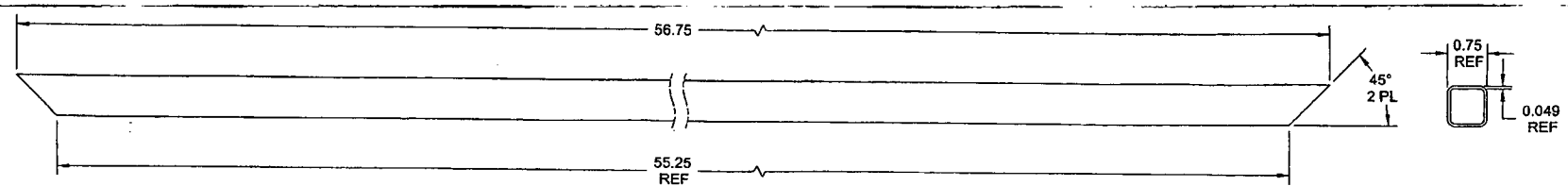
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8 7 6 5 4 3 2 1

D

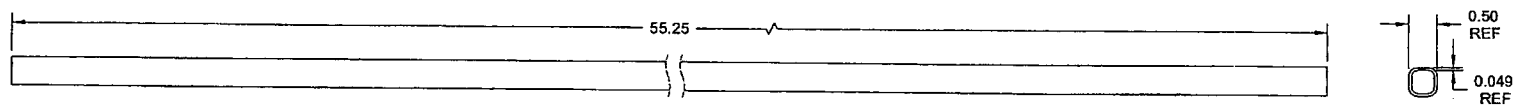
D



**D4018-1 RIB**

C

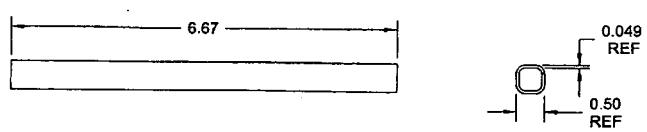
C



**D4018-3 RIB**

B

B



**D4018-5 RIB**

#65935

RELEASED  
10.08.12 UP

**NOTES:**

- 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

A

A

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ISC	DRAWING NO. <b>D4018</b>	REV. C
MFG. APPR.	h	SHEET 4 OF 4	
APPROVED	h	TITLE	SCALE
DE APPR.	h	<b>SHORT BASKET LID ASSY (350)</b>	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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